

19-7578



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A93-3307-00

Job Sheet 197357



DAS
24
9-89

Part No: RBE350A93-3307-00

Job Qty: 22 pcs 16

Part Name: Tail Gearbox Seal Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/5/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE350A93-3307-00 Rev 2A IPP Rev A 18.01.24 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier		Sign-off
						Workcenter / Supplier	Lead Time	
100	Small Fab - 1	22 pcs	8/9/19		0.00 2.20	Small Fab - 1		
						Small Fab - 2		
						Small Fab - 3		
						Small Fab - 4		
						Small Fab - 5		
						Small Fab - 6		GP 19-10-15
						Small Fab - 7		
110	QC 5	22 pcs	8/9/19		0.00 0.00	QC 5 - 10		
						QC 5 - 12		
						QC 5 - 17		
						QC 5 - 18		
						QC 5 - 19		
						QC 5 - 22		
						QC 5 - 24		
						QC 5 - 3		
						QC 5 - 43		
						QC 5 - 49		
						QC 5 - 51		DAS 61 9-89
						QC 5 - 58		
						QC 5 - 68		
						QC 5 - 9		
						QC 5 - 50		
						QC 5 - 30		
						QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	22 pcs	8/9/19		0.00 0.00	Packaging 3 - 1 - B4B		
						Packaging 3 - 2 - B4B		
						Packaging 3 - 3 - B4B		
						Packaging 3 - 4 - B4B		DAS 28 9-89
						Packaging 3 - 5 - B4B		
						Packaging 3 - 6 - B4B		
						Packaging 3 - 7 - B4B		

Plex 7/5/19 7:46 AM Dart.lajeunesse.marie

					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					140 QC 21 - FG	22 pcs	8/9/19	0.00 0.00	QC 21 - FG - 21	Dwg
									QC 21 - FG - 70	21
									QC 21 - SA - 53	9-59

Part Op 100 - (Small Fab) 1-Assemble as per DWG. ***NOTE***see deviation attached.
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

OCT 17 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91253A540	Head Head Cap Screw	68 16 22 pcs (1 ea)	100-Small Fab - 1	5172686 X 16 + 16 X 6
RBE350A93-3307-00-01	Retractor	143A 16 22 pcs (1 ea)	100-Small Fab - 1	5174554 X 8 + 025 X 8
RBE350A93-3307-00-03	Washer	143A 16 22 pcs (1 ea)	100-Small Fab - 1	5160944
RBE350A93-3307-00-05	Hex Head Cap Screw	143A 16 22 pcs (1 ea)	100-Small Fab - 1	5185485

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91253A540	22	56	0
	RBE350A93-3307-00-01	22	23	0
	RBE350A93-3307-00-03	22	18	0
	RBE350A93-3307-00-05	22	16	0

Part Specifications

Specifications could not be found.

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CANADA
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www.dartaerospace.com

Container No: S222442



Part: RBE350A93-3307-00

Job No: 197357

Serial No/Batch: S222442

Revision: 2A

Inspector:

Exp Date:

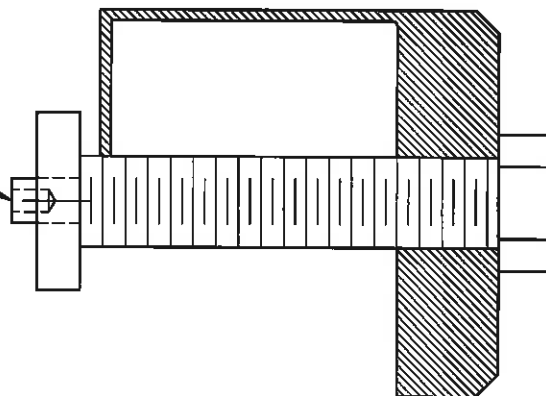
Instructions:

Date: 10/15/19

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	DESIGNED PER HELI PRODUCTS TOOLS.	9/28/09	WP	DW
2	CH'D WASHER TO P/N -03 & S.F. TO 5, CH'D ALL THREAD TO HEX HEAD CAP SCREW P/N -05 & S.F. TO 3 PER D.W., DELETED -03 WELDMENT.	11/17/09	RJC	RW
2A	CORRECTED T/N WAS RBEA93-3307-00 IS RBE350A93-3307-00.	11/5/13	RJC	RW

PRESS EXPAND UNTIL IT
RETAINS WASHER YET STILL
ALLOWS WASHER TO ROTATE.



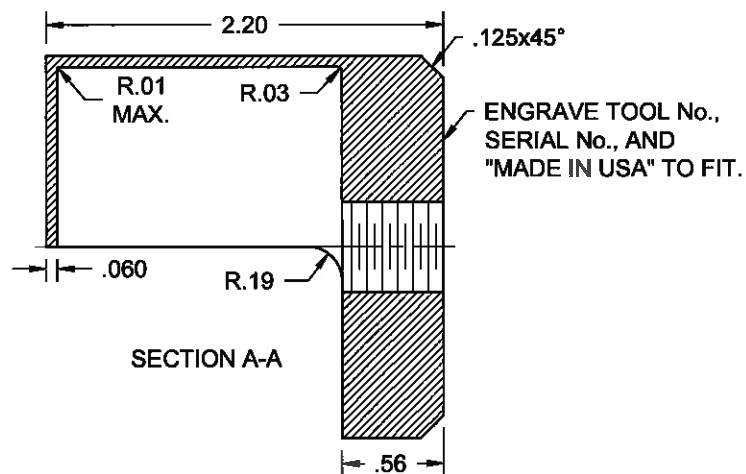
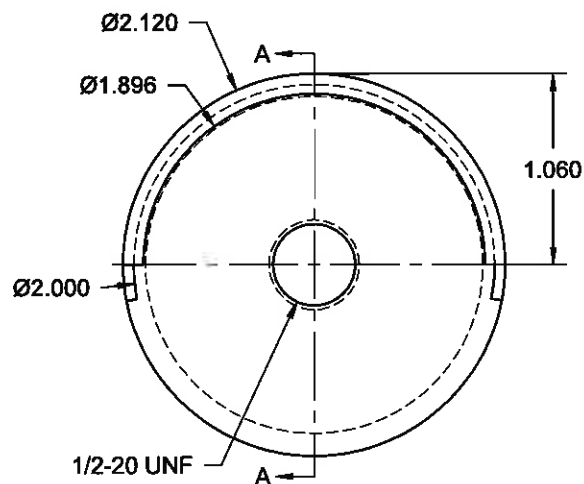
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 197357 MJS
19-07-05

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-01	1	RETRACTOR	4140 Q&T	Ø2-1/4 x 2-3/8	2
			-03	1	WASHER	1018	Ø1 x 3/8	3
		B/O	-05	1	HEX HEAD CAP SCREW	STEEL	1/2-20 UNF x 3 MCMaster CARR #92620A750	4
ASSY #								

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	FRACTIONS ± 1/32 ANGLES ± .5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 9/28/09
SHEET 1 of 4	
DRAWN BY: PERRITT APPROVED: <i>D. Med</i> HEAT TREAT: FINISH SPEC: USED ON MODEL EUROCOPTER AS350/355	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED



(-01)
EXTRACTOR

RED BARN MACHINE	
TITLE TAIL GEARBOX SEAL EXTRACTOR	
DWG NO. RBE350A93-3307-00-01	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	APPROVED <i>D. West</i>
FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT FINISH SPEC BLACK OXIDE
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350/355
SCALE NTS	DATE 9/28/09 SHEET 2 of 4

DQA: _____ Date: _____

QA Closed: 28 Date: 04/28/19**WORK ORDER NON-CONFORMANCE / UPDATE**Work Order update only ☐

Work Order: <u>197357</u> Part No. <u>RBE350A93-3307-00</u> NCR No. <u>19-7578</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																									
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Date : <u>2019-10-15</u>		Step #: _____		QTY Effective : <u>16</u>		MRB (QSI042) Approval <i>M Lee</i> March 23, 2018																																																																									
Description Work Order Deviation				Disposition		Completed By <u>DAS 61</u> <u>9-8914-10-18</u>																																																																									
As an alternative to expanding the end of the -05 Hex Head Cap Screw to secure the -03 Washer a countersunk screw can be used to secure the -03 Washer. Cut -05 Hex Head Cap Screw 2.63" long and tap 1/4"-20 hole 1.0" deep (on threaded end). Drill 0.25" hole through center of -03 Washer and CSK 0.55" x 82 deg, mfg from 303/304/316 SS, no black oxide required. Apply Loctite 262/263 to McMaster 91253A540 Screw or equivalent and assemble -03 and -05 together. (washer must rotate free),				- This deviation is acceptable. - The fit, form and function of the tool will be as originally intended.		Lead hand / Supervisor Approval Verification <u>DAS 30</u> <u>9-89</u> <u>6102 8 1 130</u>																																																																									
						QC / QA Coordinator Approval <u>68</u> <u>9-89</u> <u>OCT 15 2019</u>																																																																									
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